

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008959**Date Inspected:** 16-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Yumin**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Joe Alaniz was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

OBG Assembly Yard

This QA inspector performed UT of approximately 10% of the repaired area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member(s) is/are identified as OBG 1BW diaphragm to floor beam. The weld designations reviewed are as follows:

1. SSD44A-PP10.5-003
2. SSD46A-PP11-003
3. SSD44A-PP11.5-003
4. SSD48A-PP12-003
5. SSD44B-PP12.5-003

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

1AE & 1AAE

SMAW welding of weld joint 001 located on OBE1.

Welder is identified as Mr. Zang Wei (066413). ZPMC QC is identified as Xu Yumin.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G (4F)-Repair and repair procedure B-WR7565.

SMAW welding of weld joint 001 located on OBE1.

Welder is identified as Mr. Yun Chuanshan (050316). ZPMC QC is identified as Xu Yumin.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G (2F)-Repair and repair procedure B-WR7565.

1AAE & 1AE

SMAW welding of weld joint 004 located on OBE1A.

Welder is identified as Mr. Zang Yanbo (045196). ZPMC QC is identified as Xu Yumin.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G (4F)-FCM-Repair-1 and repair procedure B-WR7492.

NDT Observation

QA Inspector observed ZPMC Magnetic Particle (MT) Technician performing MT on various locations in the trial assembly yard. Locations are as followed:

1. OBE1-001 gouge areas (UT Rejects) were MT by ZPMC. QA Inspector noted ZPMC MT Technician observed and marked a transverse indication at 1 of 5 repair areas.

This QA Inspector performed MT of area previously tested by ZPMC and observed one transverse indication. Noted transverse indication is located on deck plate stiffener (5th from the bike path side of segment). This QA Inspector noted the engineer was not notified of the removal of work being performed at this weld. This QA Inspector issued an incident report on the above noted observation.

Miscellaneous Work In Progress

QA Inspector observed ZPMC's personnel performing various job functions in the trial assembly yard. Locations and description of work are as followed:

1. UT repair work in progress on weld OBE1A-004. QA Inspector noted welder performing the welding had burn through side plate at time of welding.

This QA Inspector was given an inspection notification (004214) on yesterday's work shift (09/15/09) for 1440. QA Inspector went to area for inspection and observed work was in progress (grit blasting). Area was not accessible between 1440- 1830. On this day (0800) this QA Inspector was given the same inspection notification for inspection and noted work (grit blasting) was still in progress and area was not accessible between the times of

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

0800-1030. Inspection notification was cancel by ZPMC QA Wang Lu.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (134-8257-0045), who represents the Office of Structural Materials for your project.

Inspected By:	Alaniz,Joe	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
